



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18520-5
Job Sheet 171733



Part No: RBT18520-5

Job Qty: 2 ea

Part Name: Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18520-5 REV:11 IPP REV A 18.02.06 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		2/22/18	0.00	0.00	Start Up Large Fab-7		EL
100	Large Fab	2 pcs		2/23/18	0.08	0.33	Large Fab 8		EL
110	QC	2 pcs		2/23/18	0.00	0.00	QC9		PD 18-3-19
130	Outsource	2 pcs		2/23/18	0.00	0.00	Outsource12		AT 18/03/23
140	Packaging	2 pcs		2/23/18	0.00	0.00	Packaging2		AT 18/03/23
150	QC	2 pcs		2/23/18	0.00	0.00	QC6		38
160	Packaging	2 pcs		2/23/18	0.00	0.00	Packaging3-2		MAR 26 2018
170	QC21-SA	2 Ea		2/23/18	0.00	0.00	QC21		MAR 28 2018

Part Op 100 - WELDING

Descriptions: 130 - Issue P/O to Groupe Altech; PO P0039353 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of

Conformity is required

140 - Receive

160 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT18520-3 ✓	Top Bolt Tab	2 Ea (1 ea)	100-Large Fab	
RBT18520-5A	Top Bolt	2 Ea (1 ea)	100-Large Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab	RBT18520-3	2	0	0
	RBT18520-5A	2	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation	Disposition

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkebury, ON K6A 1K7
 CANADA
 TEL.: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 03/16/18

Root Cause			FAULT CATEGORY		
Environment	☐	No Re-verification	Pressure/Forced	☐	Temperature/Cure
Design	☐	Operator	Bending	☐	Set-up
Doc/Data	☐	Offset/Setup	Centre Not Concentric	☐	BOM/Route
Equip/Tooling	☐	Supplier	Cracks	☐	Broken/Damage/Defect
Handling/Pre	☐	Training	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
Material	☐	Use for Testing	Cuffs	☐	Contamination
Internal Transport	☐	Poor Information	Crushing	☐	Countersink
Tribal Knowledge	☐	Rushing	Heat Treat	☐	Cut Too Short
LOA	☐	Product Improvement	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
Substation	☐	Process Improvement	Marks/Chatter	☐	Drill Holes
Past Expiry Date	☐	Manufacturing Process			
Misidentified	☐	Past Due	OTHER : _____		



Container No: S052061



Part: RBT18520-5

Job No: 171733

Serial No/Batch: S052061

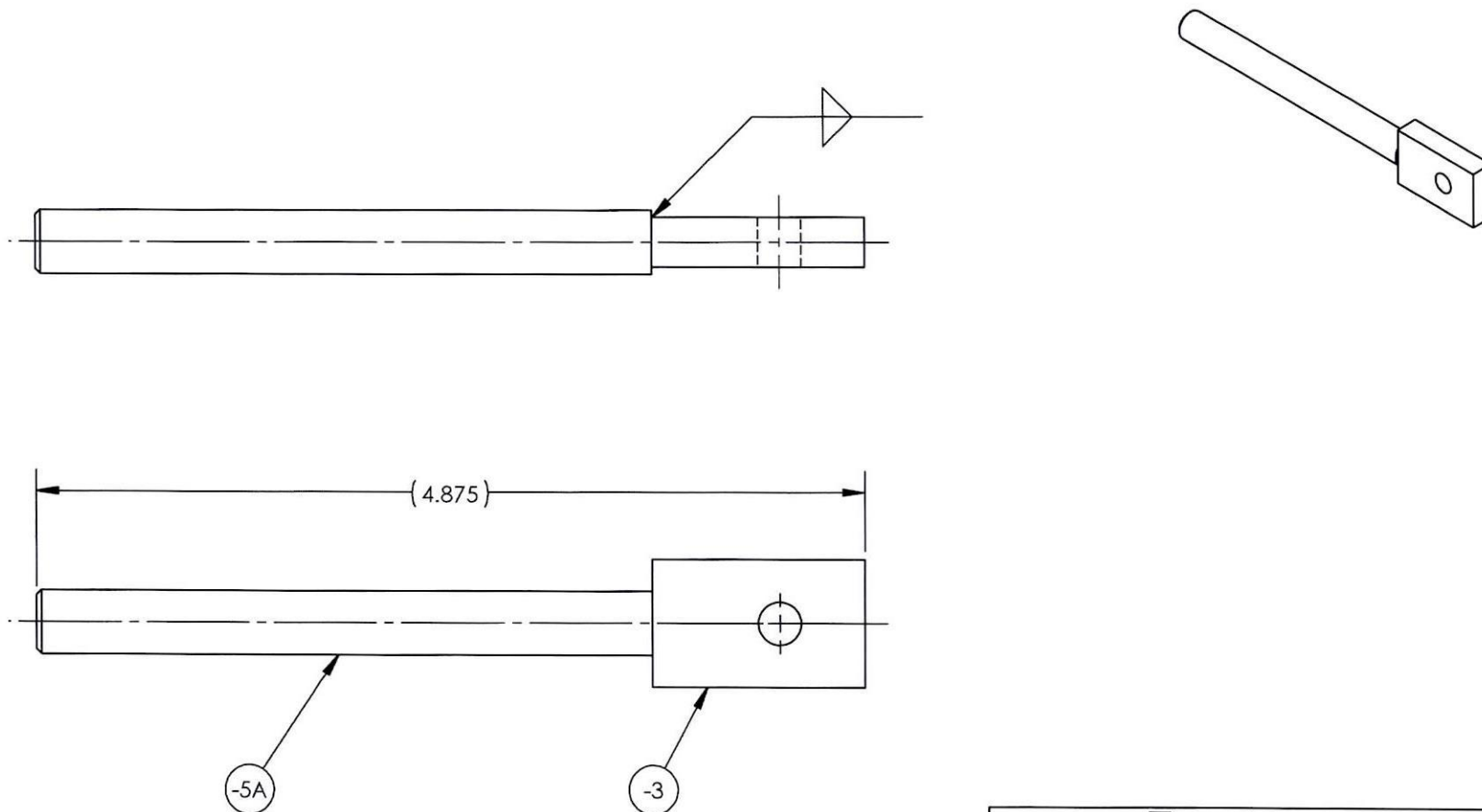
Revision: 11

Inspector:

☐	Part Lost/Missing
☐	Part Moved
☐	Drawing
☐	Finish
☐	Misread
☐	Turning Sequence

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



-5A

-3

-5

TOP BOLT WELDMENT

DART AEROSPACE	
TITLE ROTOR DAMPER TEST DEVICE	
DWG NO. RBT18520-5	REV 11
MAT'L HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2 REV D	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:1	DATE 8/17/2000
SHEET 4 OF 17	

Trances to delivered.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039353**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039353
PO Date: 3/19/18
Due Date: 3/28/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171733	RBT18520-5	Weldment -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	3/28/18	2 pcs	0 pcs <i>2x</i>	2 pcs	\$60.00/pcs	\$120.00
2	171451	RBW6405G02331-3G-09	Tail Rotor Conical Ring Puller Pin -Issue P/O to Groupe Altech; P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	3/28/18	4 pcs	0 pcs <i>4x</i>	4 pcs	\$22.50/pcs	\$90.00
Grand Total:										\$210.00

Order Notes

rec'd 4/18/23

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



Certificat de Conformité / Certificate of Compliance

(007709-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007709 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
20-Mar-2018		Aman		PO039353				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT18520-5 Rev. 171733	RBT18520-5 01 - OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	2	2	0	0	0
2	RBW6405G02331-3G-09 Rev. 171451	RBW6405G02331-3G-09 01 - ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] ASTM B633 TYPE I SC2	ZINC CH	4	4	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.